Friday, 7/21/2006 7:37:37 AM Date: Kim Johnston User: \*r **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : LUG Job Number : 28022 : 10008 **Estimate Number** : D2591 : NIA Part Number P.O. Number S.O. No. : NIA : D2591 REV D : 7/21/2006 **Drawing Number** This Issue Prsht Rev. **Project Number** : N/A : NA : MACHINED PARTS First Issue **Drawing Revision** : 27923 Material **Previous Run Due Date** : 8/9/2006 Qty: Each Written By Checked & Approved By Comment Removed from 9 Digit : Est Rev:l **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: M1010B0750X02500 ASTM A21 Steel .75"x2.5" 1.0 Comment: Qty.: 0.2340 f(s)/Unit Total: 18.7200 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) BAND SAW BAND SAW 2.0 Comment: BAND SAW Cut blanks: 2.700" long 3.0 -HAAS1 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required 84 INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 24 SECOND CHECK 5.0 QC8 Comment: SECOND CHECK

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval On Inspector				
						_ /					
				/							
				£							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
	T	Description of NC Corrective Action Section B			Verification	Approval	Approval			
DATE	STEP	Section A	Initial Deși <del>g</del> กุ Mgr	Action Description  Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector		
06/07/28	3	Le vice. Pars scrap.	Expus-	clestray No replace.	obloslo	01-08-02	Bosen	ave or		
	·									
-							74.			
						•				

Part No:	PAR #:	Fault Category:	_ NCR:	Yes No	DQA:	Date: <u>06/08/0</u> 3
NOTE: Date & initial all entries				QA: N/C C	losed:	Date:

Date:

Friday, 7/21/2006 7:37:37 AM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: LUG** 

Job Number: 28022

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: LOCA

06/08/01

7.0

DC



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Loce108102

Dart A	erospac	ce Ltd							
W/O:			W	ORK ORDER CHANGES				· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Date Qty	Approval Mfg / Design Mgr	Approval QC Inspector
						,			
		· ·							
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORI	DER NON-CONFORMANCI	E (NCR	)			
		Description of NC		Corrective Action Section B	<del></del>	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section		Approval Design Mgr	Approval QC Inspector

NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	Approval		
DATE	STEP	Section A	Initial Design Mgr	Action Description Si Design Mgr		Section C	Approval Design Mgr	Approval QC Inspector		
			-							
								; ; ;		
							,			
			·							

Part No:	PAR #:	Fault Category:	NCR:	Yes No I	DQA:	Date:
NOTE: Date & initial all entries				QA: N/C CIO	sed:	Date:

DART AEROSPACE LTD	Work Order:	28022
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

	Х	First Article	Prototype	<b>;</b>
--	---	---------------	-----------	----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.20	+/-0.030	1.200				
Ø0.510	+/-0.010	80.519	_			
0.125	+/-0.010	0.128				
2.44	+/-0.030	2,440				
0.65	+/-0.030	0.650				
0.50	+/-0.030	0.504				
						,
						·
	·				<u> </u>	s.
i						

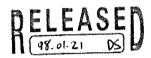
Measured by:	M	Audited by:	J.L.	Prototype Approval:	N/A
Date:	06/07/28	Date:	06/07/28	Date:	N/A

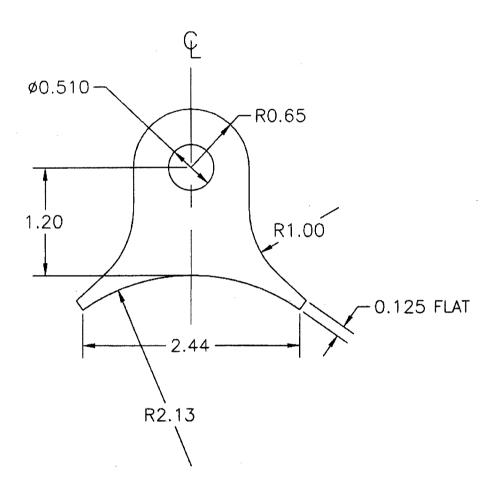
Rev	Date	Change		Revised by	Approx/ed
Α	04.08.12	New Issue	P/O D205-641-011 & DSI 9161-011	KJ/JLM OK	





	DESIG	noy	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
	CHECK	(Ep	APPROVED	DRAWING NO.	REV. D
)		LE	80	D2591 SHEET	1 OF 1
	DATE	<u> </u>		TITLE	SCALE
	98.0	1.21		GHW LUG	1:1
	Α		96:09:16	NEW ISSUE	
	В		97:06:17	RE-DESIGN TO FLAT BOTTOM	
	С		97.12.12	RE-DESIGN TO RADIUS BOTTOM	
	D		98.01.21	0.125 FLAT WAS 0.067 FLAT	•





0.063

BREAK ALL SHARP CORNERS 9.010 TO 0.020

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER